



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Reprint

D3121-25
Job Sheet 178451



Part No: D3121-25

Job Qty: 80 ea

Part Name: Delrin Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A New Issue 06-05-10 JLM IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea		6/8/18	0.00	0.00	Start Up Machining-1		JB 18-06-07
100	Hardinge	80 pcs		6/8/18	0.02	1.23	Hardinge		JB 18-06-07
120	QC	80 pcs		6/8/18	0.00	0.00	QC8		JB 18-06-11
130	Packaging	80 pcs		6/8/18	0.00	0.00	Packaging3-1 ST018		AR 18-6-13
140	QC21-SA	80 Ea		6/8/18	0.00	0.00	QC21		DAB 18-06-14
Part Op Descriptions: 100 - 1-Turn D3121-25 Cap as per Folio FA387									
DAB 21 9-00									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINR1.000	Delrin Round Bar 1" Color: Black	4.1600 ft (.052 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINR1.000	4	17	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	0.315inches $\pm$ 0.010	0.325 0.305		
2	Cap	1.000inches $\pm$ 0.010	1.010 0.990		
3	Cap	0.838inches $\pm$ 0.002	0.840 0.836		
4	Cap	0.063inches $\pm$ 0.010	0.073 0.053		
5	Cap	0.010inches $\pm$ 0.010	0.020 0.000		
6	Cap	0.230inches $\pm$ 0.001	0.231 0.229		
7	Cap	0.865inches $\pm$ 0.001	0.866 0.864		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fah ☐ Water Jet ☐ Prod. Eng. Coord. ☐ /Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		
Date : _____	Step #: _____			
Descrip Dart Aerospace Ltd. 1270 Aberdeen Street Hewitsonbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Date: 06/07/18		
		MRB (QSI042) Approval 		
		Completed By 		
		Lead hand / Supervisor Approval Verification 		
		QC / QA Coordinator Approval 		

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Container No: S078822

Part: D3121-25

Job No: 178451

Serial No/ Batch: S078822

Revision: _____

Inspector: _____

Exp Date: 06/07/2018

Instructions: _____

Cuffs

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

Broken/Damage/Defect

Inspection Incomplete/Unqualified

Contamination

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

Folio/Program	☐	Positioned Wrong	☐
Grain	☐	Outside Dimensions	☐
Weld	☐	Over/Under tolerance	☐
Wrong Stock Pulled	☐	Part Incorrect	☐
Out of Sequence	☐	Part Lost/Missing	☐
Off-set	☐	Part Moved	☐
Mislabeled	☐	Drawing	☐
Fit/Function	☐	Finish	☐
Misaligned/off center	☐	Misread	☐
		Turning Sequence	☐